

Work Order ID 155578

Tuesday, January 17, 2017 11:27:45 AM

155578

Page 1

Item ID: 650.9201

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Eyelet Bracket Assembly

Start Date: 1/5/2017

Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/31/2017

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

DAS

21

Date:

JAN 19 2017

Tooling:

Date:

Run Start

NR1

QC:

9-89

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

650.9200

A1

100

100

BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank at 2.200"

20

Ø

DAS

20

9-89

17-01-30

110

110

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB361

DWG REV: A

FOLIO REV: AA

20

Ø

DAS

20

9-89

17-01-30

17-01-31

2- deburr and break all sharp edges

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 																		
Description Work Order Deviation				Disposition																					
							Completed By																		
							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : ☐			

Tuesday, January 17, 2017 11:27:45 AM

Page 2

Reference:

Stop *NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : _____					

Tuesday, January 17, 2017 11:27:45 AM

Page 3

20x sp1702-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

Tuesday, January 17, 2017 11:27:45 AM

Page 4

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

**DAS
6
9-89**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 155578

Tuesday, January 17, 2017 11:27:45 AM

155578

Page 5

Item ID: 650.9201 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Eyelet Bracket Assembly
Start Date: 1/5/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 1/31/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00					DAS 21 9-89	MAR 07 2017	
Quality Control									

DAS
21 MAR 07 2017
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Tuesday, January 17, 2017 11:27:45 AM

Page 1
A

Work Order ID: 155578

155578

Parent Item: 650.9201

650 9201

Parent Item Name: Eyelet Bracket Assembly

Start Date: 1/5/2017

Required Date: 1/31/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 15-01-08 JLKM VERIFIED BY:DD IPP
REV:B AS PER DWG A1 15.09.14 DD VERIFIED BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M7075T6B1.000x2.500

Purchased

No

f

12.0000

1.863158

DAS

M7075T6B1 000x2 500

**

3.771'

20

9-89 1701-30

7075-T6 Bar 1.000 x 2.500

Location

Loc Qty

Loc Code

MAT

12

m135933

12

3.771'

MS21209F5-15

Purchased

No

Each

20.0000

10

MS21209F5-15

**

FF

FEB 23 2017

Heli Coil

Location

Loc Qty

Loc Code

ST296

136975

20

m135536

20

7 FF MAR 06 2017

13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

ENGINEERING CHANGE NOTICE NO.

04960

SHEET 1 OF 1

DWG NO. 650.9200

REV: A

PREPARED BY J. SOTO

DATE: 05/13/2015

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: EYELET BRACKET ASSY

APPROVED BY: ENGR *[Signature]*

MFG *[Signature]* QC *[Signature]*

EFF. NEXT ORDER

REASON: REVISED F/N 2.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155578 MLS
1701-19

PRINTED COPY OF THIS DOCUMENT IS FOR REFERENCE ONLY AND IS UNCONTROLLED

2	R	601.3806	1	HELICAL INSERT	MS21209F5-15	
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				CHANGE CATEGORY	DER REVIEW REQUIRED	
☐ PATTERN ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☒ BOM				☐ MAJOR ☒ MINOR	☐ YES ☒ NO	

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF DART AEROSPACE DBA APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE DBA APICAL INDUSTRIES IS PROHIBITED.

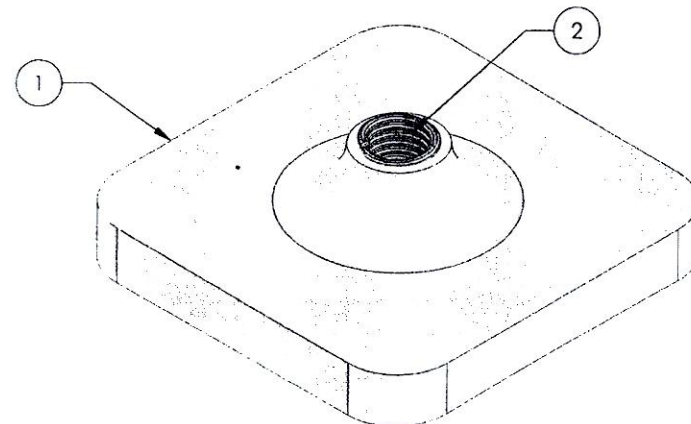
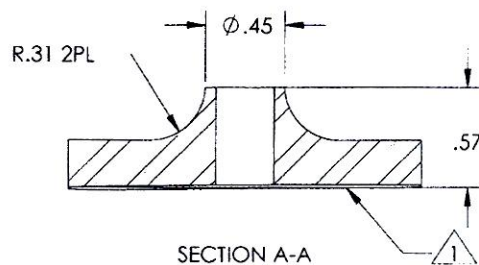
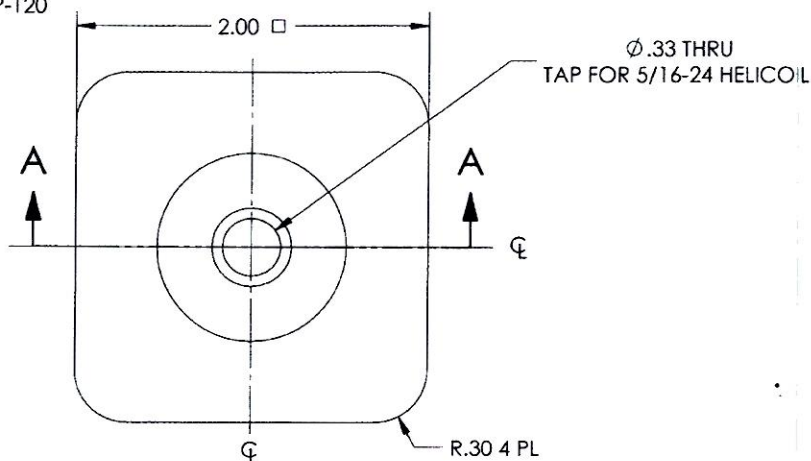
1 PART DIMENSION CONTROLLED BY 3D CAD MODEL
F/N 1 CONTROLLED BY "650.9210 EYELET BRACKET.SLDPRJT",
LAST MODIFIED: 11-17-14

2 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12

3 FINISH: IAW MPP-172 ANODIZE IAW SECTION 2.1,
PRETREATMENT IAW SECTION 3.2,
PRIMER IAW SECTION 4.3.

4. BREAK AND DEBURR ALL SHARP EDGES

5. IDENTIFY IAW MPP-120



650.9201

UNINCORPORATED ECN(S)

04960

1	2	601.2746	HELICAL INSERT	MS21209F5-20	
1	1	650.9210	EYELET BRACKET	2/3	
		650.9201	EYELET BRACKET ASSY		
	FIND #	PART #	DESCRIPTION	MATL	SPEC.
BOM Table					
QTY	PARTS LIST				
NEXT ASSY (S)	ORIGINAL DATE: 11-19-14				
646.4000	DRAWN BY: CHECKER				
	SOLD: P. BRAVO				
	DRAWING APPROVAL: P. BRAVO				
	CONTRACT NO.				
	UNLESS OTHERWISE SPECIFIED				
	DIMENSIONS ARE IN INCHES				
	TOLERANCES ARE:				
	2 PLACE DECIMALS ±0.10				
	3 PLACE DECIMALS ±0.05				
	ANGLES: 1:3				
101	CAGE CODE	DWG. NO.	REV.		
B	07M26	650.9200	A		
SCALE: NONE			SHEET: 1 OF 1		

DART 3030 ENTERPRISE CT.
AEROSPACE SUITE A
APICAL INDUSTRIES INC. VISTA, CA. 92081
DBA DART AEROSPACE (760)-724-5300

EYELET BRACKET ASSY



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35239**

Purchase Order Date 2/8/2017

PO Print Date 2/8/2017

Page Number 5 of 6

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

13 155578

650.9201 EYELET
BRACKET REV. A

2/24/2017

20.00

\$6.60

\$132.00

Yes

2/24/2017

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23370K TYPE I CLASS N

Line Total:

\$132.00

14 155505

D2348 WEARPLATE
REV. C

2/24/2017

20.00

\$6.25

\$125.00

Yes

2/24/2017

Black Anodize per MIL-A-8625F Type I or IB or IC or II or IIB Class 2, Type III Class 2

Line Total:

\$125.00

15 71401-45

ADMIN FEE

2/24/2017

1.00

\$150.00

\$150.00

Yes

2/24/2017

Line Total:

\$150.00

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

2/8/2017



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912955

Date: 21-Feb-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
8 ea	Part: 646.3310 Upper Cutter Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 19598	Rev: N/C	Line: 1
5 ea	Part: 647.4110 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 20238	Rev: N/C	Line: 10
8 ea	Part: 647.4112 Clip Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 20411	Rev: N/C	Line: 11
8 ea	Part: 647.4113 Clip Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 20458	Rev: N/C	Line: 12
20 ea	Part: 650.9201 ✓ Eyelet Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 20470	Rev: A	Line: 13
20	Part: D2348	Rev: C	

617-02-21



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912955

Date: 21-Feb-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
Quantity	Description	
	be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
	CERTIFICATE OF CONFORMANCE	
	A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS.	
	MADE IN CANADA.	
	SP17-02H	